

Work Order ID 124528

September-11-14 12:08:27 PM

124528

Page 1

Item ID: D3984 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rubber Extrusion, X-Tube, Per Foot
Start Date: 9/10/14 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 9/10/14 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: MJS Date: 14-09-18 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3984	A								

100		0.00							
100	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>25826</u>								
	Rubber extrusion								
	Possible Supplie: Accurate rubber								
	P/N: 110750006								
	Material release note required								

CK 14/09/18 100

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material release note is attached								

P 17/9/22 (100)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

September-11-14 12:08:27 PM

Page 1

Work Order ID: 124528

124528

Parent Item: D3984

D3984

Parent Item Name: Rubber Extrusion, X-Tube, Per Foot

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP rev A 09.11.12 new issue EC verified :DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
110750006 *110750006* Rubber Extrusion		Purchased	No				f	0.0000		100	**	9/19/22 (100)	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

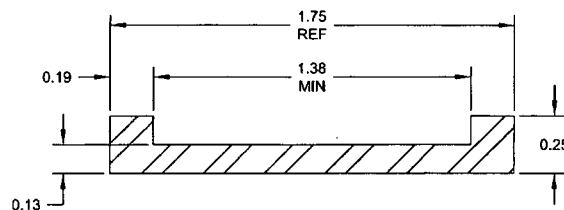
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SPECIFICATION CONTROL DRAWING



D3984-XXX

PART NUMBERING: D3984-035

BASIC PART LENGTH IN TENTHS OF AN INCH

EXAMPLE: D3984-035 = PART 3.5 INCHES LONG
EXAMPLE: D3984-100 = PART 10.0 INCHES LONG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124528 MLJ

14-09-18

RELEASED
2009-11-11
MP

NOTES:

- 1) MATERIAL: NEOPRENE BLACK 50 DUROMETER
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) PREFERRED SUPPLIER: ACCURATE RUBBER (ACR GROUP), RICHMOND, B.C., CANADA.
PART NUMBER 110750006

A		NEW ISSUE		AJS	09.11.06
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		AJS			
CHECKED			DRAWING NO.	REV. A	
MFG. APPR.			D3984	SHEET 1 OF 1	
APPROVED			TITLE	SCALE	
DE APPR.			RUBBER EXTRUSION, X-TUBE	NTS	
DATE	09.11.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25826

Purchase Order Date 9/18/2014

PO Print Date 9/18/2014

Page Number 1 of 2

Order From :
ACR GROUP INC.
12771 - NO. 5 ROAD
RICHMOND, BC V7A 4E9
CA

VC-ACR001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	604 274 9955	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	FedEx Overnight collect	Currency	CAD
Ship Acct:		FOB	FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	110750006 AS PER DWG D3984 REV. A B124528 ACR P/N: 110750006	Rubber Extrusion	10/3/2014 Yes 10/3/2014		100.00 f	\$5.50	\$550.00
Line Total:							\$550.00
2	71401-45 Procurement Quality Clauses A005 RIGHT OF ENTRY A013 SHELF LIFE CONTROLLED MATERIAL; 80% SHELF LIFE REQUIRED AT RECEIPT A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS	PROCUREMENT QUALITY CLAUSES	10/3/2014 No 10/3/2014		1.00	\$0.00	\$0.00

PO Instructions: Fedex Acc#151793240

Note:

9/18/2014

PST#

S
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DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

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P
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DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

DATE 09/19/14		SHIP VIA FED EX OVERNIGHT		ACR GROUP INC.		TERMS NET 30 DAYS	
PURCHASE ORDER NUMBER P025826			DATE ORDERED 09/18/14		00151813		SALES PERSON ROB
ORDERED	QUANTITY SHIPPED	R.O.	ITEM NUMBER	DESCRIPTION	UNIT	UNIT PRICE	AMOUNT
100	100	-	110750006	EXTRUSION DIE # 1234 50+/-5 "A" NEO DWG# D3984	FT		
FED EX ACC# 151793240				SUBTOTAL			
FREIGHT: Collect				HST			
				TOTAL AMOUNT			



12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9
Tel : (604) 274-9955
Fax : (604) 274-1013

CERTIFICATE OF COMPLIANCE

Date : 2014-09-19

Customer : Dart Aerospace LTD

Customer P.O. # : PO25826

ACR W.O. # : 151813

Item # : 110750006

Item Description: Extrusion 50 +/- 5 "A" NEO

ACR Compound : A - 106

Date Shipped: September 19, 2014

This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.

Michael Reilander
(ACR GROUP INC. REPRESENTATIVE)